

Site: Friday, 13/02/2009 1:09:06 PM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG EXTRUSION
 Job Number : 45800
 Estimate Number : 10305
 P.O. Number :
 This Issue : 13/02/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D2423
 First Issue : / / Type : PURCHASED PARTS Drawing Number : D2423 REV B1
 Previous Run : 44529 Project Number : N/A
 Material :
 Due Date : 28/02/2009 Qty: 500 Um: Each
 Written By : CL
 Checked & Approved By :
 Comment : Est G 04.09.02 Part Number D2423-108 changed to D2423KJJ
 LM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
2.0	D2423P	Lug Extrusion
Comment: Qty.: 1.0000 f(s)/Unit Total : 500.0000 f(s) Lug Extrusion		
3.0	PACKAGING 1	PACKAGING RESOURCE #1
4.0	QC6	DIMENSIONAL CHECK
5.0	PACKAGING 1	PACKAGING RESOURCE #1
6.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		



8197 C209/02/13 500dt





Job Completion



mf
09-03-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09/03/18	1.0	Cut a sample piece to check with webster hardness tester. Readings were 15-16.5 Not a perm change, just a note.		09/03/18	Sample	 09/03/18	D 09/03/18	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

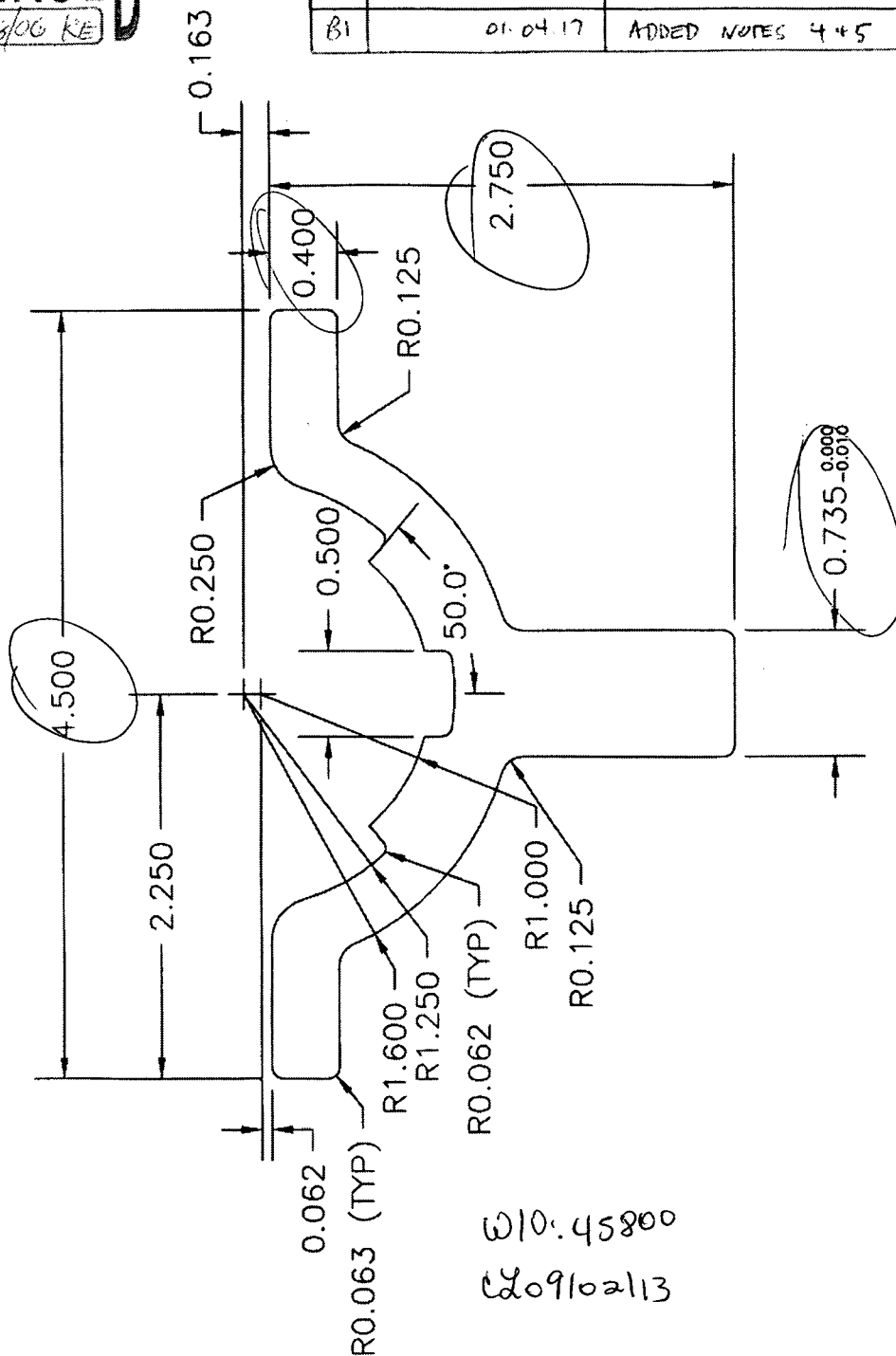
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2423	REV. B SHEET 1 OF 1
DATE 98.08.04		TITLE LUG EXTRUSION	SCALE 1:1
A	95.05.09	NEW ISSUE	
B	98.08.04	6061-T6 WAS 6005A.T5	
B1	01.04.17	ADDED NOTES 4+5 # (P)	

RELEASED
98/09/06 KE



1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)
2. NOTE: ALL DIMENSIONS ARE IN INCHES
3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4. MANUFACTURED USING CARBON INDEX DE # M5-10866
5. PART NUMBER IS D2423-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108" LONG)



INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

MANIFEST DATE
03-01-09
MANIFEST NUMBER
655604
SALES ORDER NUMBER
43757

ACCT# 00046024

SHIP TO
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN
PHONE 613-632-5200

SOLD TO / PURCHASER
DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY ON
K6A 1K7 CN
PHONE 613-632-5200

TERMS / FREIGHT
O / P

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE

CREDIT REP
HAMBROOK, PAU
905-508-3250

SALES REP

LOCATION PIC TRAILER NUMBER SALES MAN FIELD SALES REP CUST SERVICE REP
57364 59358 Kutter A 450-435-6551 Burton D 905-427-2227

JOB BILL OF LADING NUMBER
08389455

CUSTOMER ID ORDER DATE CUSTOMER PO NUMBER
46024 02/13/09 8197

46024		02/13/09		8197																	
ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION		NBR OF PKGS	GROSS POUNDS	NET QUANTITY	UNIT	QUANTITY DUE									
				CUSTOMER PART NUMBER	LENGTH	FABRICATION DESCRIPTION															
					CUTTING TOLERANCE	SHIPPING TOLERANCE															
01	63	KG M PC	0 0 0	DAA-5-2 D2423P	6061 /T6 8' +3/16 " -0 "	MILL CERTIFICATE OF COMP (+015-015,0072-0053)		2	954	940 170.69 70	KG M PC	0 0 0									
				LOT/TKT DETAIL:		43757010 / 305303 43757010 / 305304		1 1	477 477	470 470		35 PC 35 PC									
													7048	=560 P/A							
													2	954	940	KG					

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

PAGE

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DATE OF DELIVERY

DRIVER

ATTN: CUSTOMER ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Cert. Date	Cert. No.	Sales Order	Page
03/01/09	188040	43757	1
Cust. PO	B/L No.	Lot	Date
8197	08389455	43757010	3/01/09

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-5-2	8" MILL 6061 T6	D2423P
Gross Weight	954 KGS		
Net Qty	940 KG	70 PC	171 M 2 PKG
Specification	Die Desc		
ASTM B221-08			

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	301.4 / 43.7	282.2 / 41.0	14.4	.0	92

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI
.65	.29	.26	.06	.88	.06	.04	.02

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Conchita Ko, QA Manager Signature Aluminum Canada Inc

